

Work Order ID 64429

Monday, December 06, 2010 8:55:23 AM

Page 1

Item ID: D3917-3

Accept

Revision ID:

Item Name: Washer

Start Date: 12/6/2010 Start Qty: 20.00

Required Date: 12/13/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3917

A

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA876 & DWG

FOLIO REV: A

DWG REV: A

DEBURR

0.00

B.A 10/12/08

4 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B.A 10/12/08

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3917-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Washer

Start Date: 12/6/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00



QC Memo 0.00

Quality Control

130 Identify as per dwg & Stock Location: 94 0.00



Packaging Memo 0.00

Packaging

140 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/12/08

4

5

10/12/08

10/12/08

MF
10-12-08

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Picklist Print

Monday, December 06, 2010 8:55:28 AM

Page 1

Work Order ID: 64429

Parent Item: D3917-3

Parent Item Name: Washer



Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750		Purchased	No			100	f	105.8870	0.02	0.421053			



Delrin Round Bar 0.75"



Location	Loc Qty	Loc Code
MAT	49.35	
116183	49.35	
MAT050	56.537	
112418	0.12	
115472	56.417	

0.4900

ft

Y.A 10/12/08

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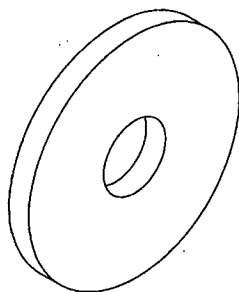
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

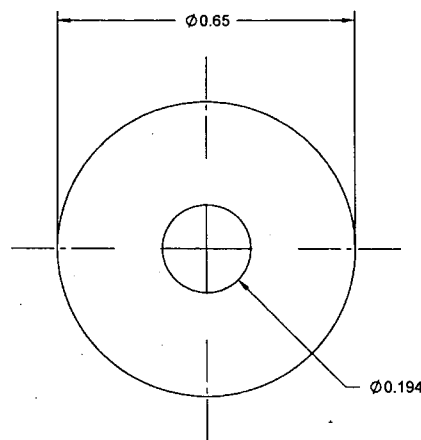
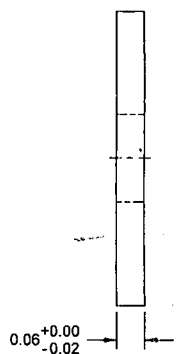
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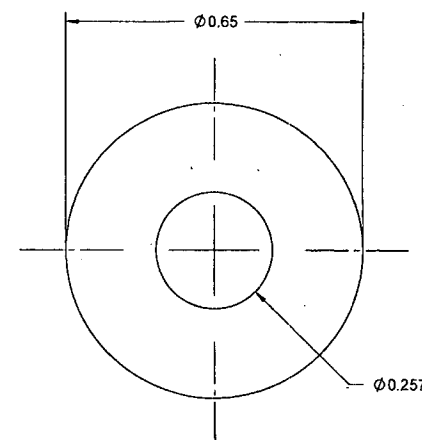
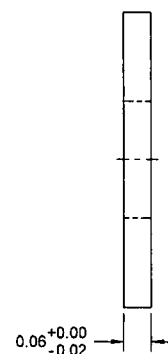
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *411429*
251012-4



ISO VIEW



D3917-1 WASHER



D3917-3 WASHER

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: DELRIN II ISOE OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A		NEW ISSUE		JPH	10.01.29
REV.	DESCRIPTION	BY	DATE		
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 1	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3917			
MFG. APPR.	<i>[Signature]</i>	TITLE WASHER (350 BASKET)		SCALE NTS	
APPROVED	<i>[Signature]</i>	DATE 10.01.29			
DE APPR.	<i>[Signature]</i>				

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